

Work Order ID 52487

September 26, 2009 10:28:25 AM



Page 1

Item ID: PB67-43001-229

Accept



Setup Start



Revision ID: BIC PECU 09-678

Stop



Item Name: Outer Tube

Start Date: 09/28/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 09-09-26 Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



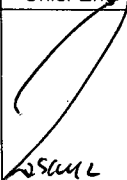
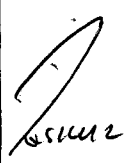
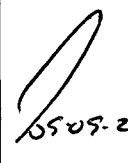
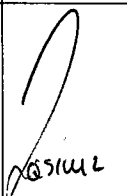
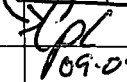
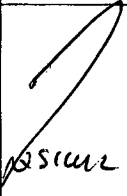
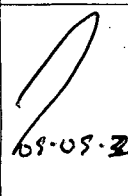
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								
100		0.00							
	BAND SAW					2	2		
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	1- cut to length and cut angle on one end of tube as per dwg 2- deburr								
									M.A 09/09/27
110		0.00							
	CONVENTIONAL MILLING MACHINE					2	2		
Mill Conv	Memo	0.00							
Conventional Milling Machine	1- drill holes and mill slot as per dwg PB67-43001 2- deburr								
									M.A 09/09/27
120		0.00							
	QC5- Inspect part completeness to step on W/O					2			
QC	Memo	0.00							
Quality Control									

(P7C)

09-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-229 PAR #: 5412-695-04 Fault Category: Machined Parts NCR: (Yes) No DQA: 2 Date: 09-10-21
 Resolution: (A) Scrap / (B) rework Disposition: (A) scrap / (B) rework QA: N/C Closed Date: 09-10-21

NCR: <u>52487</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
(A) 09/09/28	110	- slot on wrong side (1) - series of dents due to bad clamping in machine Part ran out / pulled out of vise. 2 part scrap.		Scrap & replace qty 2 in <u>111432</u> restock 1 of 2 lengths for <u>111432</u>	M.A 09/09/28	S 09/09/28		 09-09-28
(B) 09/09/28	110	R.C. operator error / bot hole .250 is off by .588 → Forgot to retake origin after flipping the part. → operator error (1 part) lack of attention		Fill hole with weld per 051004 on one side only & insert a plug. Ensure no weld build up on the inside & ground out side flush. Re-check all per drawing.	M.A 09/09/28  09-09-29	S 09/09/28		 09-09-29

NOTE: Date & initial all entries

Work Order ID 52487

September 26, 2009 10:28:25 AM



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Item ID: PB67-43001-229

Accept



Setup Start



Revision ID: B1

Item Name: Outer Tube

Stop



Start Date: 09/28/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1- bend end cap to fit on tube □ 2-Weld end cap as per dwg PB67-43001 □ 3-grind weld flush

CP 09 09 29 (X2)

140



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

=> 8/01/09

(X2)

4

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> 8/01/09

(X2)

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52487

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Page 3

Item ID: PB67-43001-229

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Outer Tube

Start Date: 09/28/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: Stores

0.00

09.10.20

Packaging

Memo

0.00

2 0

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/10/20 MF

Quality Control

MF 09-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 26, 2009 10:28:25 AM

Page 1

Work Order ID: 52487

Parent Item: PB67-43001-229RevB1

Parent Item Name: Outer Tube


Start Date: 09/28/2009

Required Date: 10/02/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			130	f	83.4000	10.7895			
												
6061T6 RDTUBE 1.750 X 0.65W												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

83.4

108551

2.24

109397

4.47

110885

16.69

111432

60

PB67-43001-233RevB1

Manufactured No

100

Each

11.0000

2.0000



Outer Tube End Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

41573

11

Y.A
09/09/27
20.000

09-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

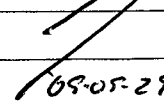
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 52487
Description: OUTER TUBE	Part Number: B67-43001-229
Inspection Dwg: B67-43001-229 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

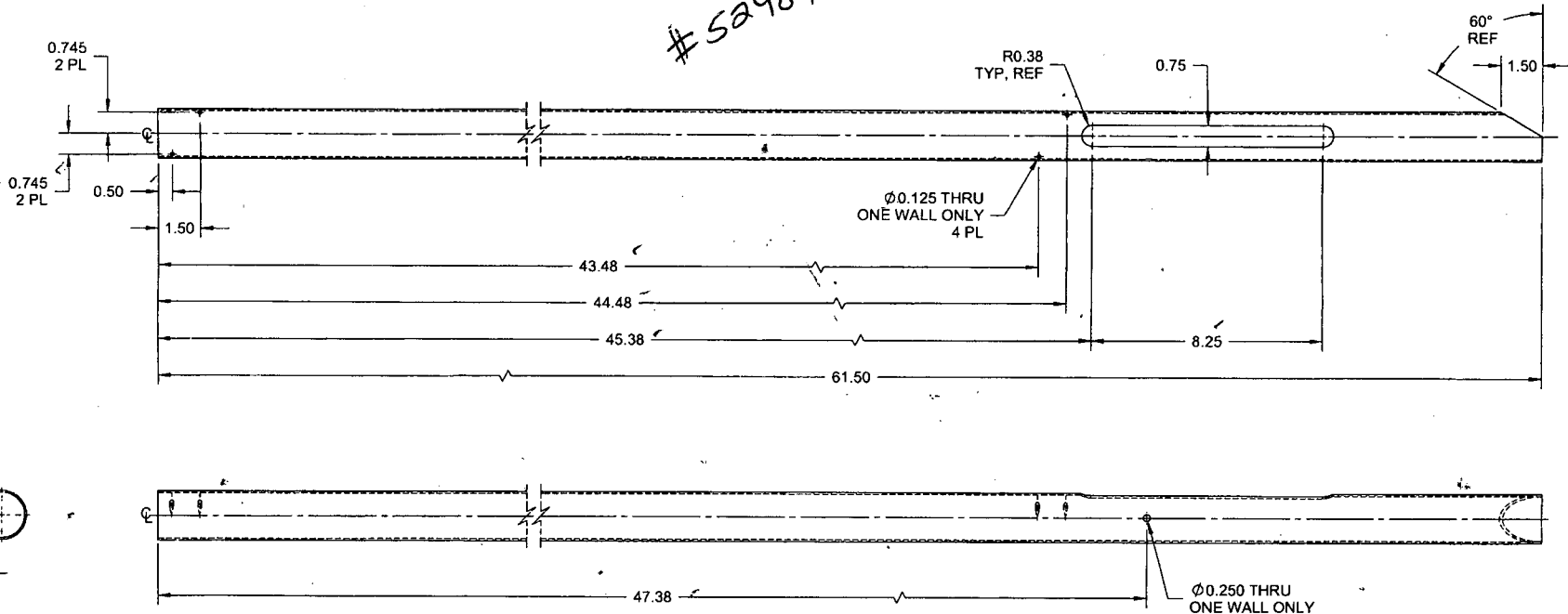
☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.745	+/- .010	0.745	✓			
0.745	+/- .010	0.745	✓			
0.50	+/- .030	0.500	✓			
1.50	+/- .030	1.500	✓			
0.75	+/- .030	0.752	✓			
60°	+/- 1/2°	60°	✓			
1.50	+/- .030	1.505	✓			
∅ 0.125	+0.004/- .001	∅ 0.128	✓			
43.48	+/- .030	43.48	✓			
44.48	+/- .030	44.48	✓			
45.38	+/- .030	45.38	✓			
8.25	+/- .030	8.250	✓			
61.50	+/- .030	61.50	✓			
47.38	+/- .030	47.38	✓			
∅ 0.250	+0.005/- .001	∅ 0.251	✓			
∅ 1.750(ref)	+/- .010	∅ 1.751	✓			
0.065 (ref)	+/- .010	0.063	✓			

Measured by: H.A	Audited by: 	Prototype Approval:	N/A
Date: 09/09/27	Date: 09-05-28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

#52487



B67-43001-229 OUTER TUBE

RELEASED
2009-09-24
MB

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T1.750V.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.00 lbs

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 19 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.		DESCRIPTION	BY	DATE	
DESIGN	RW				
DRAWN	AS				
CHECKED	AS				
MFG. APPR.	MB				
APPROVED	MB				
DE APPR.	N/A				
DATE	09.02.27				
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C	
		DRAWING NO. B67-43001-229		SHEET 1 OF 1	
		TITLE OUTER TUBE		SCALE NTS	
		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries